

Work Order ID 56300

February 17, 2010 2:28:02 PM



Page 1

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/17/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-2-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3793

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793 1 Dwg Rev: *A* 1 Prog Rev: *A* 12-

Deburr if necessary

304.040

B 10-2-22

(13)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-2-22

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

510/02/24

(412)

P70 ->

Dart Aerospace Ltd

| W/O: <u>56300</u> | | WORK ORDER CHANGES | | | | | |
|-------------------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10/12/24 | #120 | Took Qty +1 Part For QC inspection template | S | 10/12/24 | 41 | | S 10/12/24 |
| | | | | | | | |

Part No: D3793-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 56300

February 17, 2010 2:28:02 PM



Page 2

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/17/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793

9/5/10/03/01 (12x)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/03/01

(12)

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:15pm FINISH TIME: 3:45pm OVEN TEMPERATURE: 320°F

⇒ 10/03/04

(12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 56300

February 17, 2010 2:28:02 PM



Page 3

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/17/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*PK 10-3-3**12*

170

Identify as per dwg & Stock Location: *F248*

0.00



Packaging

Memo

0.00

Packaging

*10/03/03**X12*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/03/03**MF 10-3-3*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

February 17, 2010 2:28:06 PM

Page 1

Work Order ID: 56300

Parent Item: D3793-1

Parent Item Name: Wearshoe

Start Date: 2/17/10

Required Date: 2/24/10

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304S20GA | | Purchased | No | | | 100 | sf | 173.0046 | 6.2126 | 8.1 | | |



304/316 .040 Sheet



18 10-2-22

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

173.0046053

110076

0.40253684

112567

38.0765789

112885

30.733

113062

95.2723

113077

8.52018947

113062

13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 56300 |
| Description: Wearshoe | | Part Number: | D3793-1 |
| Inspection Dwg: D3793 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.188 | +0.005/-0.001 | .191 | ✓ | | | |
| 0.300 x 0.300 | +/-0.010 | 303 x 304 | ✓ | | | |
| 1.885 | +/-0.010 | 1.888 | ✓ | | | |
| 2.000 | +/-0.010 | 1.998 | ✓ | | | |
| 5.00 | +/-0.030 | 5.00 | ✓ | | | |
| 8.00 | +/-0.030 | 8.00 | ✓ | | | |
| 14.00 | +/-0.030 | 14.00 | ✓ | | | |
| 20.00 | +/-0.030 | 20.00 | ✓ | | | |
| 14.066 | +/-0.010 | 14.066 | ✓ | | | |
| 18.983 | +/-0.010 | 18.983 | ✓ | | | |
| 23.900 | +/-0.010 | 23.900 | ✓ | | | |
| 27.400 | +/-0.010 | 27.400 | ✓ | | | |
| 29.400 | +/-0.010 | 29.400 | ✓ | | | |
| 32.900 | +/-0.010 | 32.900 | ✓ | | | |
| 0.040 | +/-0.010 | .036 | ✓ | | | |
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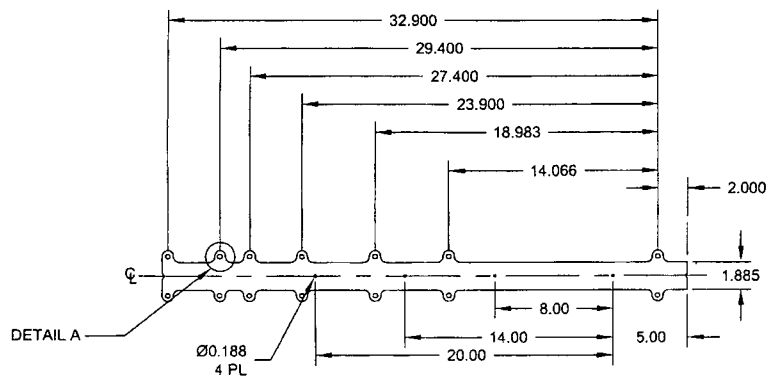
| | |
|---------------------|---------|
| Measured by: | EB |
| Date: | 10-2-22 |

| | |
|--------------------|----------|
| Audited by: | S |
| Date: | 10/02/24 |

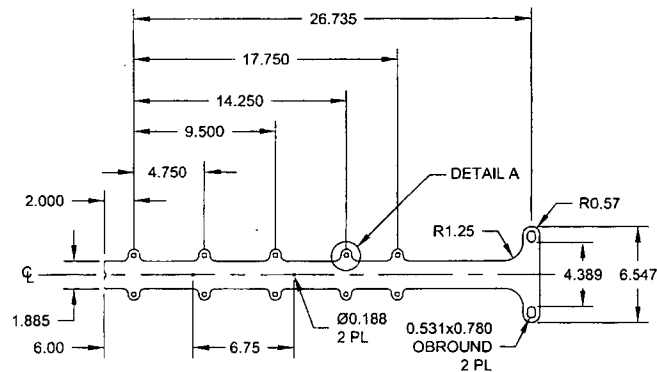
| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.05.30 | New Issue | KJ/DD | DD |

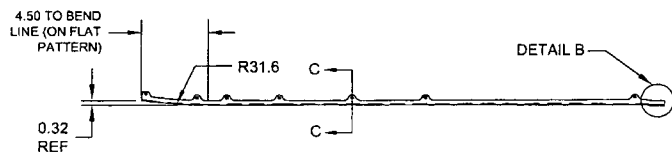
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08.05.14

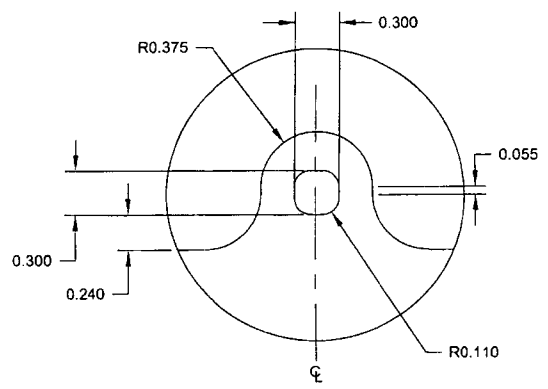
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

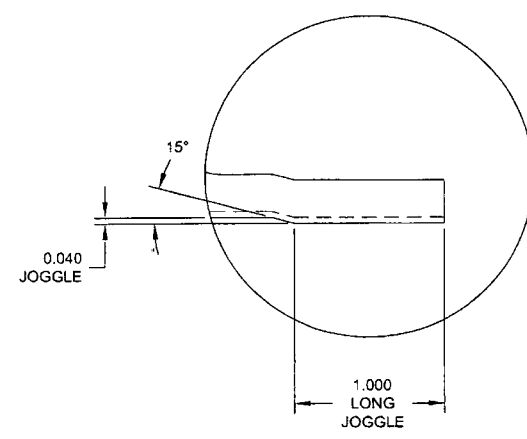
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54300
BP10-2-17

| | | | | |
|------------|-----------|---|---|--------------|
| A | NEW ISSUE | | PH | 08.05.14 |
| REV. | | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE USA, INC PORT HADLOCK, WA | | |
| DRAWN | PH | | | |
| CHECKED | | | DRAWING NO. | REV. A |
| MFG. APPR. | | | D3793 | SHEET 1 OF 2 |
| APPROVED | | | TITLE | SCALE |
| DE APPR. | | | WEARSHOE | NT |
| DATE | 08.05.14 | | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC | |

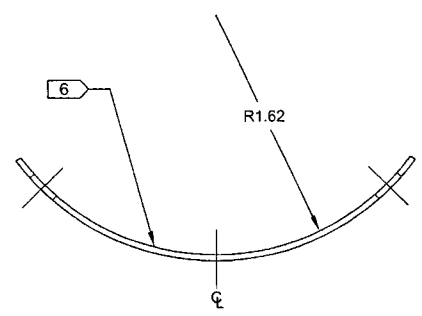
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

300 7.540
240 7.1080
540
1.060
1.665 72.965

w/o 56300

RELEASED
08-05-23

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | PH | PORT HADLOCK, WA | |
| CHECKED | PH | DRAWING NO. | REV. A |
| MFG. APPR. | PH | D3793 | SHEET 2 OF 2 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | NTS |
| DATE | 08.05.14 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

8 7 6 5 4 3 2 1